

Date: Thursday, 3/20/2008 9:54:16 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 03.250 SUPPORT
Job Number : 38128	
Estimate Number : 10387	
P.O. Number :	Part Number : D29401
This Issue : 3/20/2008 S.O. No. :	Drawing Number : D2940 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 37966	Material :
Written By :	Due Date : 4/3/2008 Qty: 20 Um: Each
Checked & Approved By : <u>08 03 20</u>	
Comment : Est. S 02.11.26 Reformat; Added P/O KJ	
Est Rev:D Added priming as per Rev B 07-04-30 JLM	
est E 08.03.19 Re-format Ec verified by DD	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DSK081

D2940-1 TURNING DETAIL



Comment: Qty.: 0.5000 Each(s)/Unit Total: 10.0000 Each(s)

D2940-1 TURNING DETAIL

Batch: B40301

25 08/08/20 (9)

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

1- Machine as per Folio FA079

2- Tumble & Deburr

M.A 08/08/21

28 08/08/20

(18)

3.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

M.A 08/08/21

(18)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

27 08/08/27

(18)

5.0

POWDER COATING

POWDER COATING



M108523



(18X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

*****Mask Inside Surface as per Dwg D2940*****

M.L 08/08/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/20/2008 9:54:16 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 03.250 SUPPORT

Job Number: 38128

Part Number: D29401

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2940 and QSI 005 4.3.

2T 06-09-18

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 08 09 19

(12)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

ml 08 09 19

(18)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38128
Description: Ø3.250 Support	Part Number:	D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	3.211	3.216							
B	4.946	4.966							
C	0.718	0.738							
D	0.090	0.110							
E	3.564	3.584							
F	0.022	0.042							
G	3.444	3.464							
H	0.112	0.132							
I	2.170	2.190							
J	4.451	4.471							
K	0.413	0.433							
L	0.913	0.933							
M									
N									
HAAS Section									
AA	0.240	0.260		0.250	0.250	0.250	0.250		
AB	0.490	0.510		0.500	0.500	0.500	0.500		
AC	0.140	0.160		0.158	0.159	0.159	0.159		
AD	3.510	3.530		3.520	3.519	3.516	3.515		
AE	1.633	1.673		1.651	1.651	1.656	1.654		
AF	1.493	1.513		1.499	1.504	1.502	1.497		
AG	0.040	0.060		0.047	0.050	0.054	0.048		
AH	0.188	0.193		0.189	0.189	0.189	0.189		
AI	0.140	0.160		0.150	0.150	0.149	0.150		
AJ	2.518	2.538		2.523	2.523	2.523	2.522		
AK	0.040	0.060		0.049	0.049	0.050	0.049		
AL	0.010	0.020		0.015	0.015	0.015	0.015		
AM	0.140	0.160		0.150	0.149	0.150	0.150		
AN	0.350	0.450		0.387	0.375	0.391	0.385		
AO	0.240	0.260		0.250	0.250	0.250	0.250		
AP	0.150	0.170		0.155	0.152	0.156	0.151		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.260	0.267		0.260	0.260	0.261	0.261		
AT	0.053	0.073		0.063	0.063	0.063	0.063		
AU	4.118	4.138		4.127	4.127	4.128	4.128		
AV									
Accept/Reject									

Measured by:	K. A
Date:	08/08/21

Audited by:	JML
Date:	08/08/27

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	B

DART AEROSPACE LTD	Work Order:	38128
Description: Ø3.250 Support	Part Number:	D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
Lathe Section									
A	3.211	3.216							
B	4.946	4.966							
C	0.718	0.738							
D	0.090	0.110							
E	3.564	3.584							
F	0.022	0.042							
G	3.444	3.464							
H	0.112	0.132							
I	2.170	2.190							
J	4.451	4.471							
K	0.413	0.433							
L	0.913	0.933							
M									
N									
HAAS Section									
AA	0.240	0.260		0.250	0.250	0.250	0.250		
AB	0.490	0.510		0.500	0.500	0.500	0.500		
AC	0.140	0.160		0.157	0.157	0.159	0.159		
AD	3.510	3.530		3.516	3.517	3.523	3.523		
AE	1.633	1.673		1.651	1.651	1.659	1.659		
AF	1.493	1.513		1.501	1.496	1.499	1.506		
AG	0.040	0.060		0.048	0.055	0.047	0.054		
AH	0.188	0.193		0.189	0.189	0.189	0.189		
AI	0.140	0.160		0.150	0.147	0.150	0.148		
AJ	2.518	2.538		2.525	2.525	2.525	2.525		
AK	0.040	0.060		0.049	0.049	0.053	0.051		
AL	0.010	0.020		0.015	0.015	0.015	0.015		
AM	0.140	0.160		0.150	0.149	0.150	0.150		
AN	0.350	0.450		0.384	0.386	0.380	0.380		
AO	0.240	0.260		0.250	0.250	0.250	0.250		
AP	0.150	0.170		0.150	0.158	0.160	0.152		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.260	0.267		0.261	0.261	0.261	0.261		
AT	0.053	0.073		0.063	0.063	0.063	0.063		
AU	4.118	4.138							
AV									
Accept/Reject									

Measured by:	YA
Date:	08/08/22

Audited by:	SM
Date:	08/08/27

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	BE

DART AEROSPACE LTD		Work Order:	38128
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	19	210	11	12	By	Date
Lathe Section									
A	3.211	3.216							
B	4.946	4.966							
C	0.718	0.738							
D	0.090	0.110							
E	3.564	3.584							
F	0.022	0.042							
G	3.444	3.464							
H	0.112	0.132							
I	2.170	2.190							
J	4.451	4.471							
K	0.413	0.433							
L	0.913	0.933							
M									
N									
HAAS Section									
AA	0.240	0.260		0.250	0.250	0.250	0.250		
AB	0.490	0.510		0.500	0.500	0.500	0.500		
AC	0.140	0.160		0.158	0.158	0.158	0.156		
AD	3.510	3.530		3.520	3.521	3.521	3.526		
AE	1.633	1.673		1.673	1.654	1.654	1.655		
AF	1.493	1.513		1.500	1.500	1.496	1.497		
AG	0.040	0.060		0.055	0.048	0.051	0.048		
AH	0.188	0.193		0.189	0.189	0.189	0.189		
AI	0.140	0.160		0.150	0.150	0.150	0.150		
AJ	2.518	2.538		2.525	2.525	2.525	2.525		
AK	0.040	0.060		0.048	0.050	0.050	0.048		
AL	0.010	0.020		0.015	0.015	0.015	0.015		
AM	0.140	0.160		0.150	0.150	0.150	0.149		
AN	0.350	0.450		0.378	0.380	0.379	0.379		
AO	0.240	0.260		0.250	0.250	0.250	0.250		
AP	0.150	0.170		0.151	0.156	0.154	0.152		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.260	0.267		0.262	0.261	0.261	0.262		
AT	0.053	0.073		0.063	0.063	0.063	0.063		
AU	4.118	4.138		4.128	4.128	4.130	4.130		
AV									
Accept/Reject									

Measured by:	<i>SA</i> / <i>N.A.</i> 08/07/22
Date:	08/08/23

Audited by:	<i>am</i>
Date:	08/10/27

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	<i>AE</i>

DART AEROSPACE LTD		Work Order:	38128
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	14	15	16	By	Date
Lathe Section									
A	3.211	3.216							
B	4.946	4.966							
C	0.718	0.738							
D	0.090	0.110							
E	3.564	3.584							
F	0.022	0.042							
G	3.444	3.464							
H	0.112	0.132							
I	2.170	2.190							
J	4.451	4.471							
K	0.413	0.433							
L	0.913	0.933							
M									
N									
HAAS Section									
AA	0.240	0.260		.250	.250	.250	.250		
AB	0.490	0.510		.500	.500	.500	.500		
AC	0.140	0.160		.148	.150	.150	.150		
AD	3.510	3.530		3.528	3.528	3.528	3.528		
AE	1.633	1.673		1.654	1.654	1.654	1.654		
AF	1.493	1.513		1.498	1.498	1.498	1.498		
AG	0.040	0.060		.050	.050	.050	.050		
AH	0.188	0.193		.189	.189	.189	.189		
AI	0.140	0.160		.152	.150	.149	.148		
AJ	2.518	2.538		2.528	2.528	2.528	2.528		
AK	0.040	0.060		.050	.06	.05	.050		
AL	0.010	0.020		.015	.015	.015	.015		
AM	0.140	0.160		.158	.150	.150	.150		
AN	0.350	0.450		.375	.375	.375	.375		
AO	0.240	0.260		.250	.250	.250	.250		
AP	0.150	0.170		.156	.160	.160	.160		
AQ	0.053	0.073		.063	.063	.063	.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.260	0.267		.262	.262	.262	.262		
AT	0.053	0.073		.063	.063	.063	.063		
AU	4.118	4.138		4.130	4.130	4.130	4.130		
AV									
Accept/Reject									

Measured by:	<i>SA</i>
Date:	<i>08/08/20</i>

Audited by:	<i>cm</i>
Date:	<i>08/08/22</i>

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	<i>AE</i>

DART AEROSPACE LTD		Work Order: 38128
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				17	18	19	20		
Lathe Section									
A	3.211	3.216							
B	4.946	4.966							
C	0.718	0.738							
D	0.090	0.110							
E	3.564	3.584							
F	0.022	0.042							
G	3.444	3.464							
H	0.112	0.132							
I	2.170	2.190							
J	4.451	4.471							
K	0.413	0.433							
L	0.913	0.933							
M									
N									
HAAS Section									
AA	0.240	0.260		.250	.250	.250			
AB	0.490	0.510		.500	.500	.500			
AC	0.140	0.160		.150	.150	.150			
AD	3.510	3.530		3.525	3.525	3.525			
AE	1.633	1.673		1.654	1.654	1.654			
AF	1.493	1.513		1.500	1.500	1.500			
AG	0.040	0.060		.050	.050	.050			
AH	0.188	0.193		.190	.190	.190			
AI	0.140	0.160		.150	.150	.150			
AJ	2.518	2.538		2.525	2.525	2.525			
AK	0.040	0.060		.050	.050	.050			
AL	0.010	0.020		.015	.015	.015			
AM	0.140	0.160		.150	.150	.150			
AN	0.350	0.450		.375	.375	.375			
AO	0.240	0.260		.250	.250	.250			
AP	0.150	0.170		.160	.160	.160			
AQ	0.053	0.073		.063	.063	.063			
AR	101.64	105.64		103.63	103.64	103.64			
AS	0.260	0.267		.260	.261	.261			
AT	0.053	0.073		.063	.063	.063			
AU	4.118	4.138		4.125	4.125	4.125			
AV									

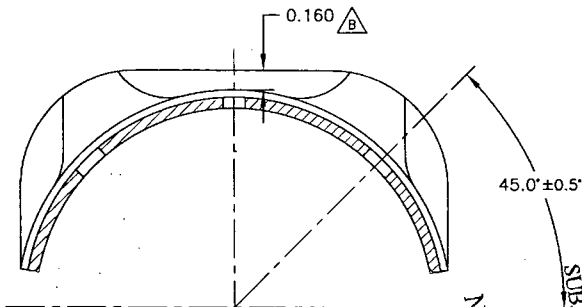
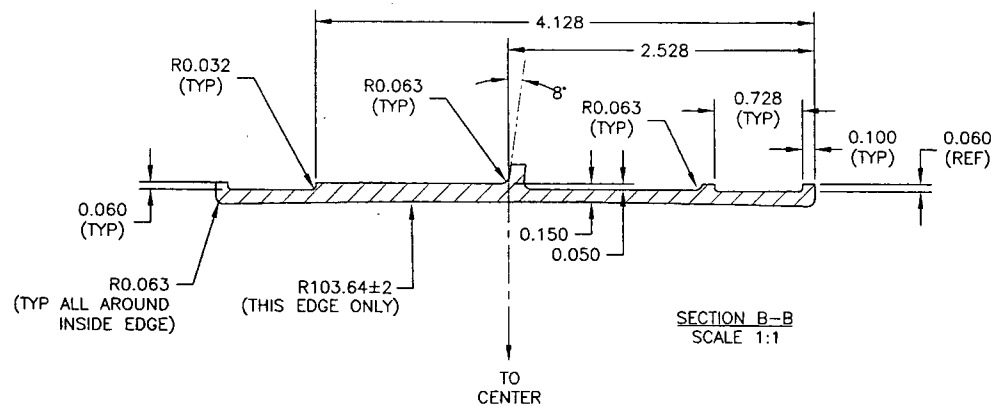
Accept/Reject

Measured by:	28/08/25
Date:	28/08/25

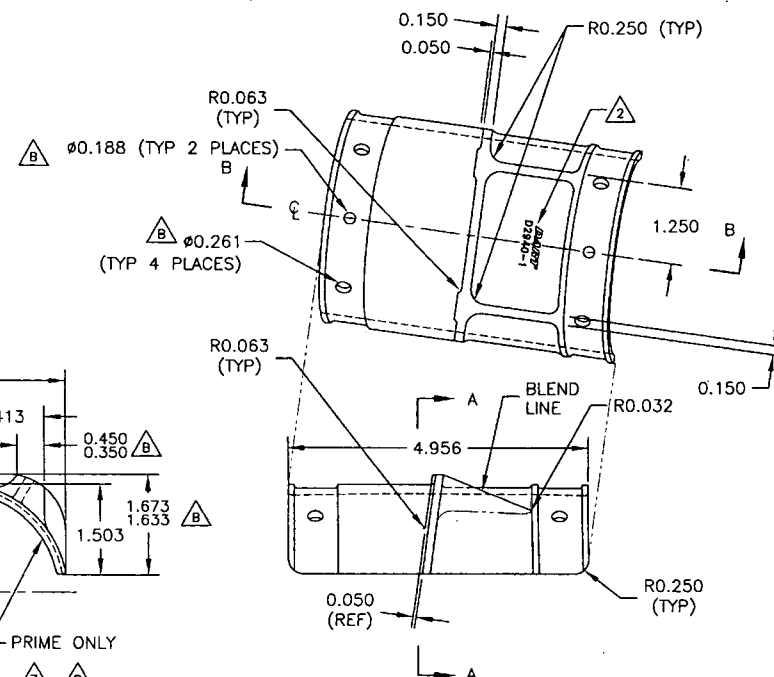
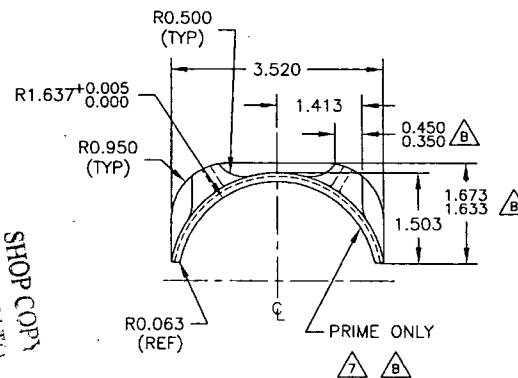
Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	

RELEASED
07.04.24 UP
PER ECR 827



SECTION A-A
TOOLING HOLE DETAIL
SCALE 1:1



D2940-1

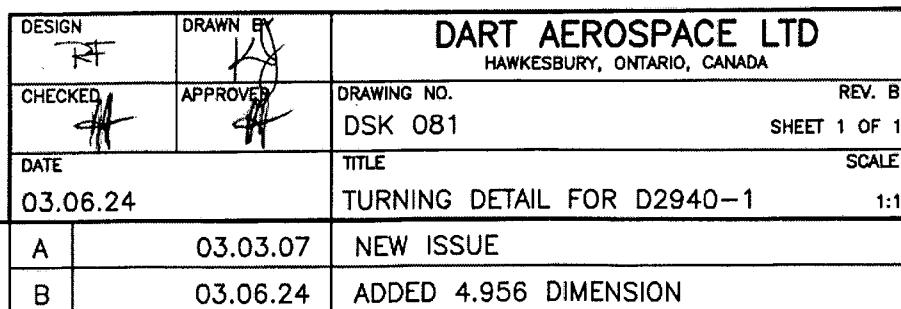
- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA
WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

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WITHOUT NOTICE
WORK ORDER
NO. 38128

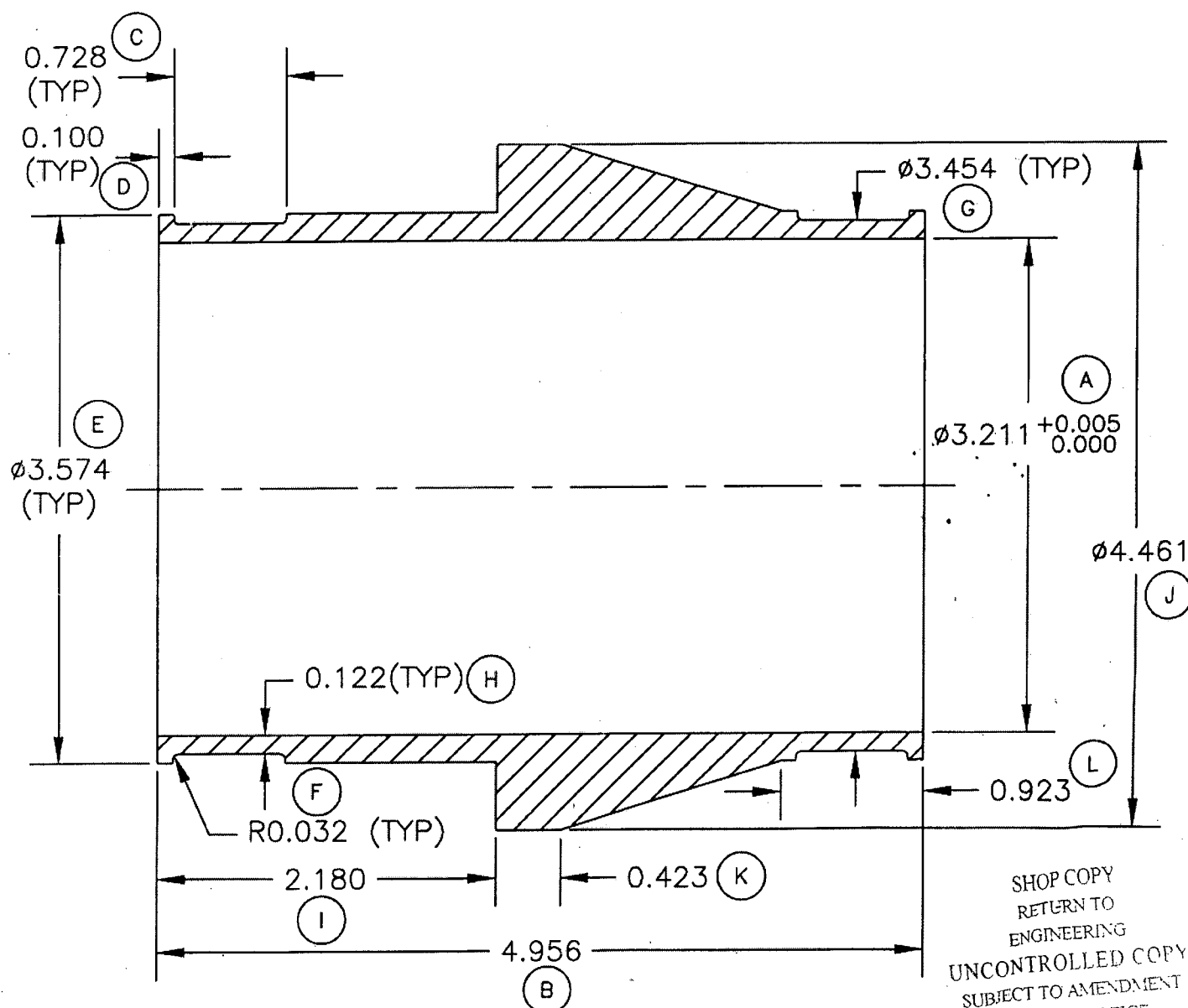
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B	07.03.16	UPDATE PER NCR 642, PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	97	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	07.03.16	TITLE
		DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
		DART
		DRAWING NO. D2940
		REV. B
		SHEET 1 OF 1
		SCALE 1:2
		Ø3.250 SUPPORT



RELEASED
03-07-01 #



D2940-1 TURNING DETAIL

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38128

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